Work Ord Friday, June 04												Page 1
Item ID: Revision ID: Item Name:	D3999-9 Angle	,		Accept						-	art	
Start Date: Required Date: Reference:	6/4/2010 : 6/10/2010	Start Qty: 2.00 Req'd Qty: 2.00	1 1881 1884 1885 1881 1884 1885			t Item : tomer:					118811181	
Approvals:	Process Pl QC:	an:	Date: 16-4-67	Tooling: SPC (Y/N):			ate:					
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	To	ool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3999	Re A	vision Nbr		-				Mar	Not	pu 24	-To	
100 Waterjet		Memo		0.00			,	1 4		10-6-		

FLOW CNC Waterjet

6061.063

Memo

1-Cut as per Dwg
Dwg Rev:
Prog Rev:

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

HB10-6-10

Quality Control

Dart Aerospace L	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Res	solution:						Date: _	
NCR:	:			R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign 8	Verific Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date	000		Office Ling	do inspector
				<u> </u>					

Work Order ID 59479	Work	Ord	ler ID	5947
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Friday, June 04, 2010 2:47:09 PM



Page 2

Item ID:

D3999-9

Accept

Setup Start

Revision ID:

Start Date:

Item Name: Angle

Required Date: 6/10/2010

6/4/2010

Start Qty: 2.00

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Date: _____ QC:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

130

Brake NC

Quality Control

Bend as per dwg

0.00

0.00

SD 10/06/11

Brake NC

140

QC5- Inspect part completeness to step on W/O

& ioloce lu

Memo

Memo

	•									
W/O:			W	ORK ORDER CHAN	IGES					
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	legory:	NCR:	Yes 1	No DQ/	A:	Date:	
		olution:								
NCR:		•	WORK ORI	DER NON-CONFORI	MANCE	(NCR)				
DATE	STEP	Description of NC		······································	ection B		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 59479

Friday, June 04, 2010 2:47:09 PM



Page 3

Item ID:

D3999-9

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Angle

Required Date: 6/10/2010

6/4/2010

Start Qty: 2.00 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:	
pp. o . a.s.	

Process Plan: _____ Date: ____

Tooling:

Date:

Run

Start

Stop



Date:_____

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

Operation

Description

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan

Qty Code

Reject Accept Qty

Reject Number

Insp. Stamp

QC21- Final Inspection - Work Order Release

0.00



QC **Quality Control**

Memo

0.00

10-6-14 10-6-14

Dart Aerospa	ce	Ltd
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W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	7	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
	Reso	olution:							Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng		n & ate	Verific Secti		Approval Chief Eng	Approval QC Inspector
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<u>-</u>										

Picklist Print

Friday, June 04, 2010 2:47:14 PM

Work Order ID: 59479

Parent Item:

Comments:

D3999-9

Parent Item Name:

Angle

IPP rev A 10.01.20 new issue Prelim EC verified by:DD IPP rev B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name

Item ID M6061T6S.063

Replacement Mfg/ Purch Purchased

10.05.10 ecn 10-562 EC verified by:DD

Bin Item Location No

Primary Last Location

Route Seq ID sf

130.7

130.7

Unit of Qty on Measure Hand 130.7000

Qty per Kit Total 0.0248

Qty Otv 0.0496

Issued

B10-6-10

Date Status **Issued**

Page 1



6061-T6 .063 Sheet

Location

MAT21 113608

100

Loc Qty Loc Code

113608

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W/O:			W	ORK ORDER CHANG	ES				•
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA :		_ Date: _	72 711112
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	l)	-		
DATE	STEP	Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
	O L	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	59479
Description: ANCEL	Part Number:	03999-9
Inspection Dwg: \(\) 3999-9 Rev: \(\)		Page 1 of 1

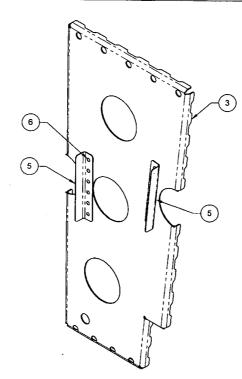
FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le 🗀	Proto	type			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
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Measured by:	NΩ	Audited by:		Prototype Approval:	N/A
Date:	10-6-10	Date:	10/06/10	Date:	N/A
	<u>U </u>	L	-0(00/10		

1	Rev	Date	Change	Revised by	Approved
-	Kev	Date	New Issue	KJ/JLM	
	A		New 1930e		· .

			·		· .
ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	х		D3999-041	BAFFLE ASSEMBLY, AFT	JCA-M47-1-02
2		х	D3999-043	BAFFLE ASSEMBLY, FWD	JCA-M47-1-03
3	1	 	D3999-1	BAFFLE	
4		1	D3999-3	BAFFLE	
5	2	2	D3999-5	ANGLE	
6	12	12	MS20470AD4	RIVET	·



D3999-041 BAFFLE ASSEMBLY, AFT

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COMY SUBJECT TO AMENDMENT WITHC'IT NOTICE WORK ORDER

D3999-043 BAFFLE ASSEMBLY, FWD

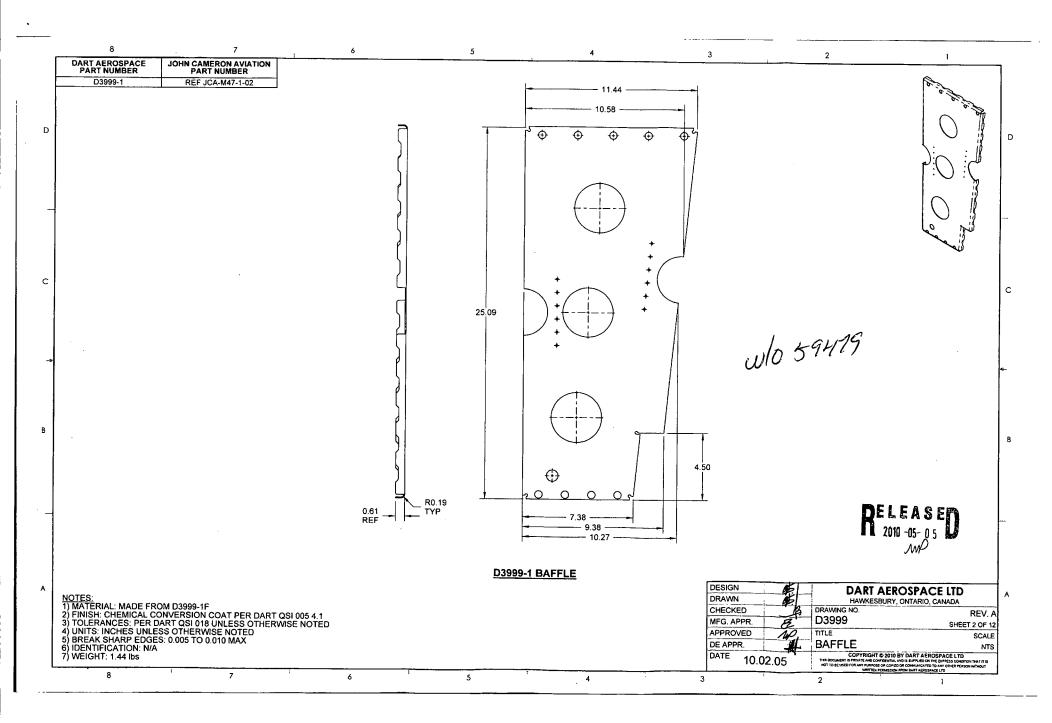
RELEASED ...

Α	NEW IS:	SUE		AS	10.02.05
REV.			DESCRIPTION	BY	DATE
DESIG DRAW		A		ROSPACE L'	
CHECK	(ED	B	DRAWING NO.		REV. A
MFG. A		匿	D3999		HEET 1 OF 1
APPRO	OVED	1.0	TITLE		SCALE
DE API	PR.	-#-	BAFFLE		NTS
DATE	10.0	2.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIA NOT TO BE USED FOR ANY PURPOSE OR COPI	BY DART AEROSPACE LAND IS SUPPLIED ON THE EXPRESS ED OR COMMUNICATED TO ANY OTH IN FROM DART AEROSPACE LTD.	CONOMINATOR IS

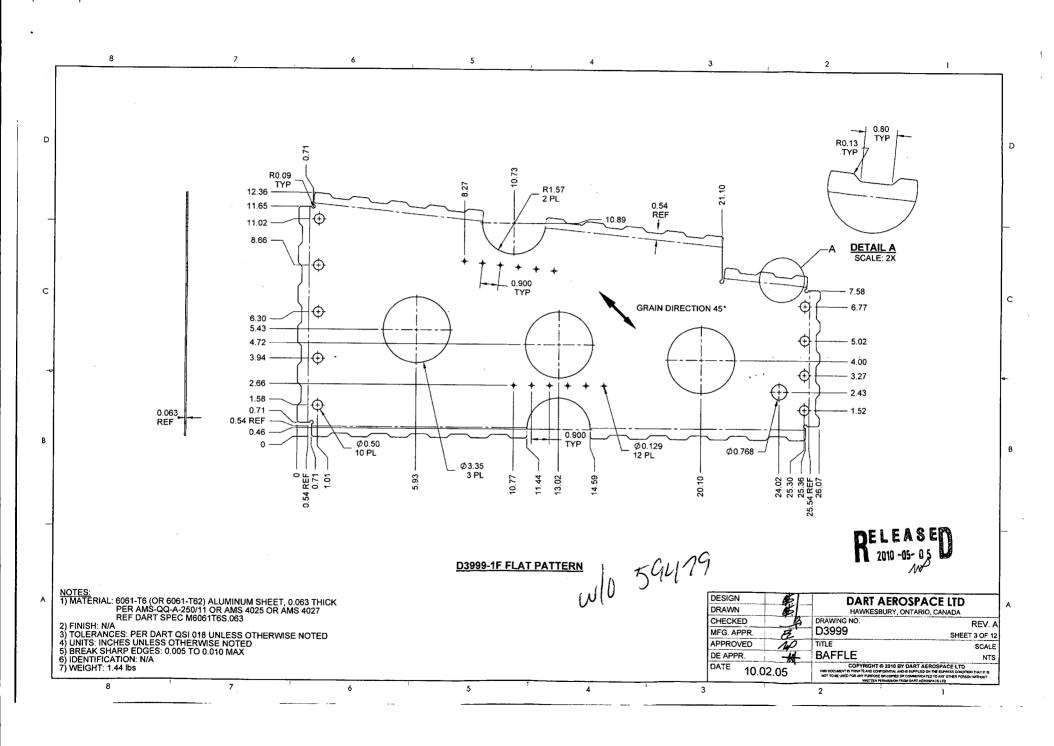
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3999-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT (-041): 1.51 lbs
8) WEIGHT (-043): 1.84 lbs

Dart Aerospace Ltd

		W	ORK ORDER CHANG	GES					
STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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:	PAR #:	Fault Cate	gory:	NCR	: Yes I	No DQ	A:	Date:	
		WORK ORD	ER NON-CONFORM	ANCE	(NCR)			. , , , , , , , , , , , , , , , , , , ,
	Description of NC	Corrective Action Section B				Verific	ation	Approval	Approval
	Section A	Section A	Chief Eng	Action Description Chief Eng		Sign & Date			Chief Eng
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	:Res	PAR #:PAR #:	STEP PROCEDURE CHARACTER STEP PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PROCEDURE CHANGE Fault Category: Besolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Initial Action Description	PAR #: Fault Category: NCR Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC	STEP PROCEDURE CHANGE By PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes INTERPORT NCR: Yes	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQA Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

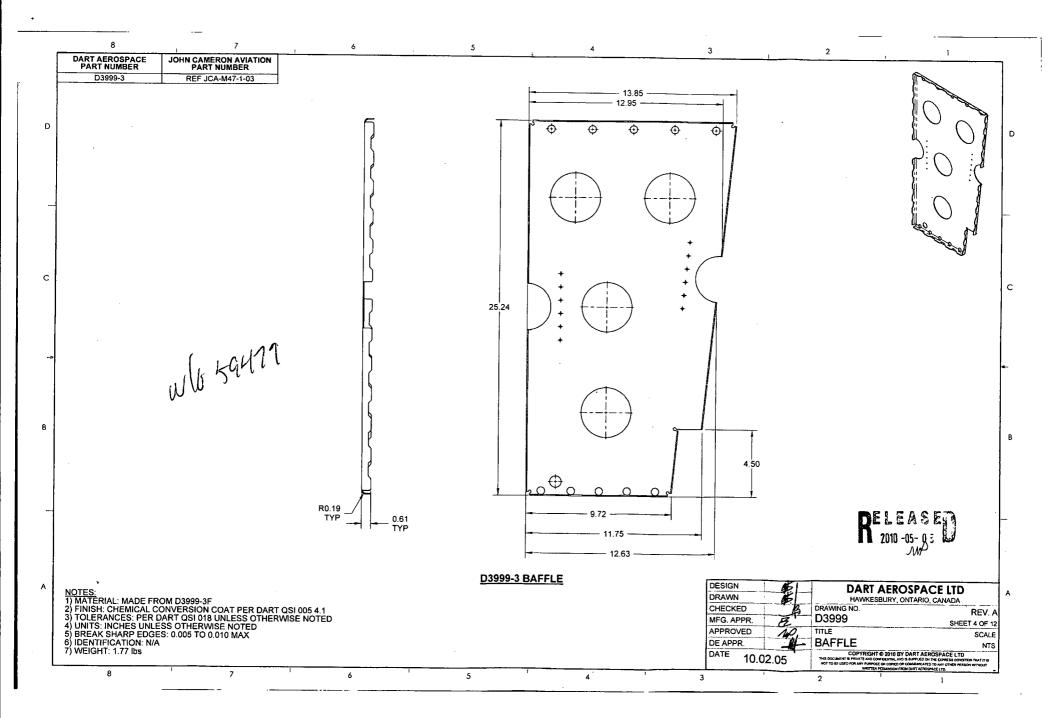


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Resolution:				Disposition: QA: N/C Closed: Date:							
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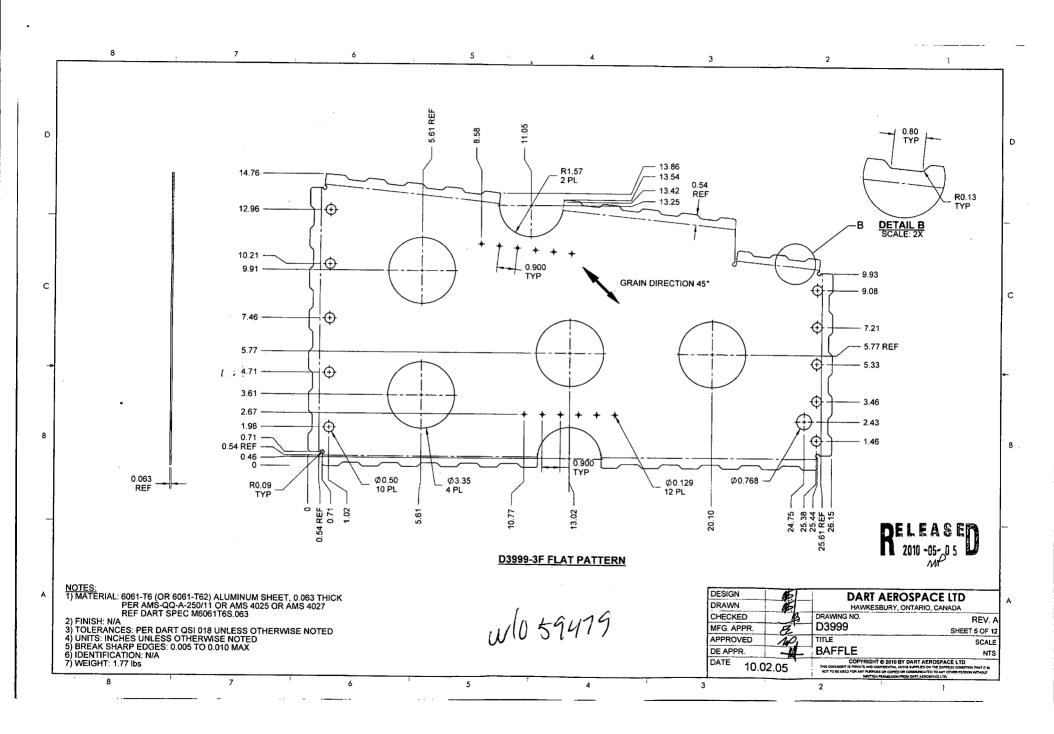
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Dart Aerospace	: Ltd
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W/O:			W	ORK ORE	DER CHAI	NGES					
DATE	STEP	PRO	CEDURE CH	ANGE	i.		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:			Disposition: QA: N/C Closed: Date:								
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W/O:			WC	RK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·			B *
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	Jory:	_ NCR: Yes	No DQ	A:	Date: _	L
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DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
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6 5 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER REF JCA-M47-1-02 REF JCA-M47-1-03 D3999-5 D D 0.83 Wlo 59479 С 5.50 REF 0.83 R0.12 REF В **D3999-5 ANGLE** DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: MADE FROM D3999-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 6 OF 12 APPROVED TITLE SCALE DE APPR. **BAFFLE** NTS COPYRIGHT & 2010 BY DART AEROSPACE LTD

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Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	GES		- 1.7			
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		\	WORK OR	DER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
VII.7.										

5.50 R0.20 TYP BEND LINE-GRAIN DIRECTION 1.55 0.78 REF 0.40 TYP 0.040 0.50 TYP Ø0.129 0.900 REF 6 PL TYP D3999-5F FLAT PATTERN

NOTES: 1) MATÉRIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.040 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

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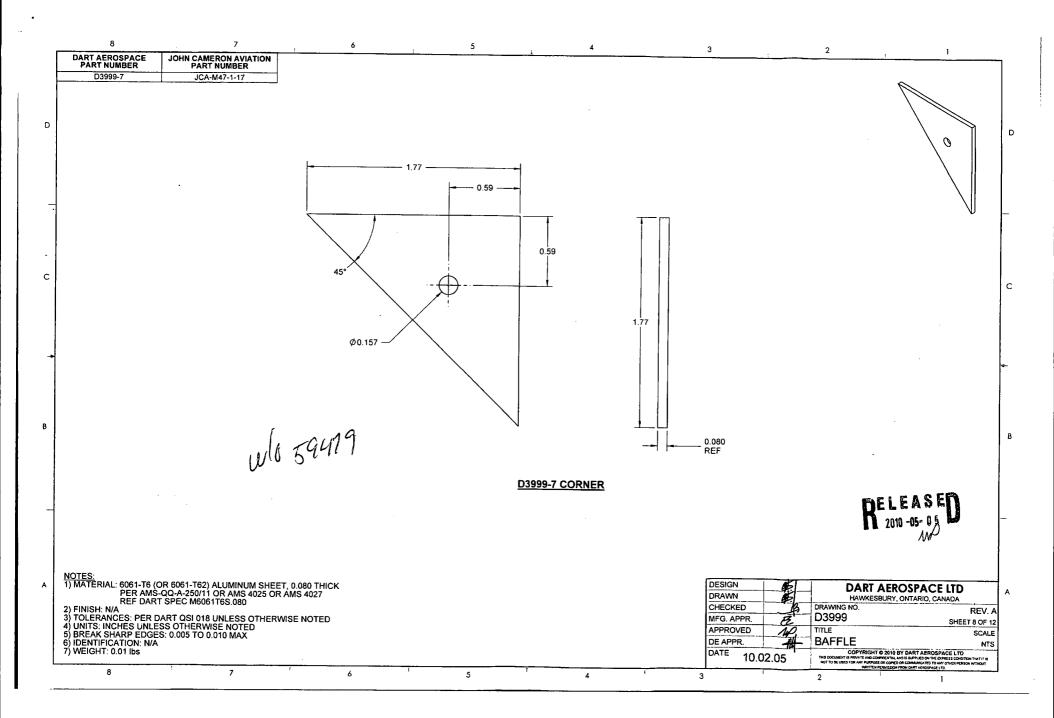
DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 7 OF 12 APPROVED TITLE SCALE BAFFLE DE APPR. NTS DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
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Part No		PAR #:							
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Dart Aerospace Ltd

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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-9 JCA-M47-1-18 ¢ρ 1.38 REF 1.38 REF R0.19 1.38 REF **D3999-9 ANGLE** W (059479 DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: MADE FROM D3999-9F
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT. 0.02 lbs DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3999 MFG. APPR. SHEET 9 OF 12 APPROVED TITLE SCALE BAFFLE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
	JOIL!	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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8 7 5 • Ø0.768 .384 GRAIN DIRECTION £ 1.38 .48 .276 . 296 BEND LINE - 0.68 0.063 REF REF D3999-9F FLAT PATTERN W/0 59479 NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S0.063 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs CHECKED DRAWING NO. REV. A D3999 MFG. APPR. SHEET 10 OF 12 APPROVED TITLE SCALE BAFFLE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			WC	ORK ORDER CHAN	GES					
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	R	esolution:	Disposition	າ:	QA:	N/C Clo	sed:		Date:	
NCR:	•••		NORK ORDI	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
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									in	

DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-11 JCA-M47-1-19 ٩D 1.00 REF 0.62 - R0.20 wlo 59479 **D3999-11 EARTH TAB**

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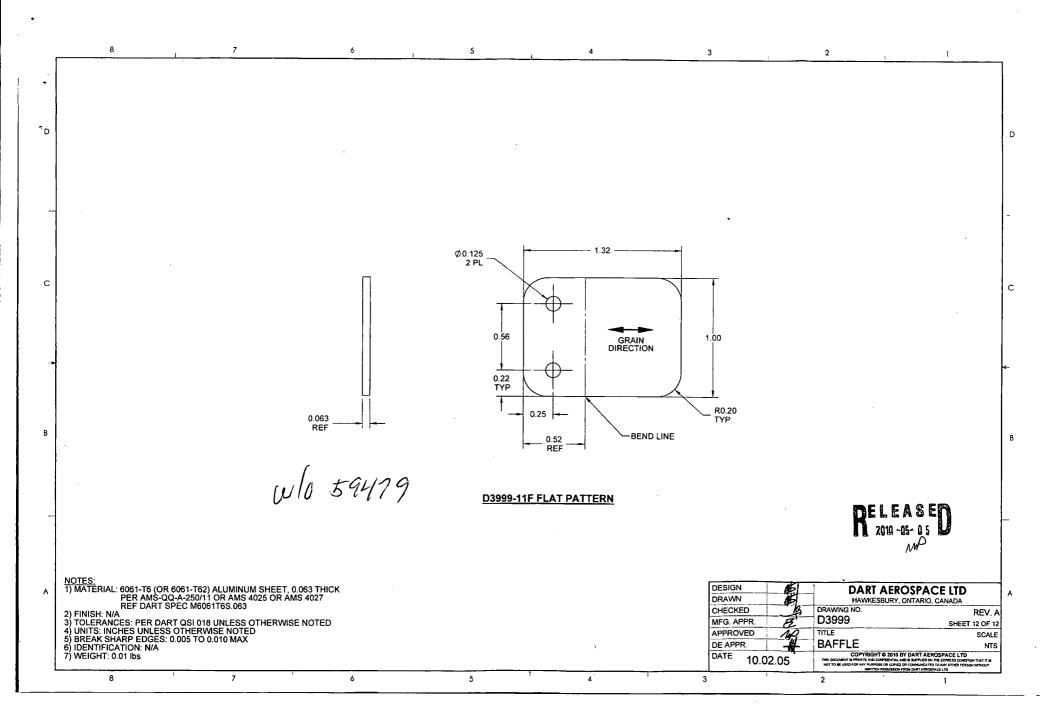
DESIGN	15	DART AFRO	OSPACE LTD
DRAWN	45		INTARIO, CANADA
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	_ E	D3999	SHEET 11 OF 12
APPROVED	10	TITLE	SCALE
DE APPR.	-41-	BAFFLE	NTS
DATE 10.0	2.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND	DART AEROSPACE LTD IS SUPPLIED ON THE EXPRESS CONSTION THAT IT IS COMMUNICATED TO ANY OTHER PERSON WITHOUT

NOTES:
1) MATERIAL: MADE FROM D3999-11F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

2

Dart Aerospace Ltd	Dart	Aer	'osp	ace	Ltd
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W/O:		WORK ORDER CHANGES											
DATE STEP		PROCEDURE CHANGE			E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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			7-14-1										
Part No		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	A:	Date:				
		olution:											
NCR:			WORK ORDI	ER NON-CONFORM	MANCE (NCR)				16-37-5-44			
DATE	STEP	Description of NC Section A	Corrective Action Section E					cation	Approval	Approval			
	J.E.		Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector			
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Dart	Aero	space	Ltd
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W/O:			W	ORK ORDER CHAN	GES							
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:			Fault Category:			NCR: Yes No DQA: Date:						
	Re	esolution:							Date:			
NCR:		\	WORK ORE	ER NON-CONFORM	IANCE	(NCR)					
DATE	STEP	Description of NC	Corrective Action Section B					ation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
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